



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3238-13
Job Sheet 169035



Part No: D3238-13

Job Qty: 4 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/29/17

Job Tracking No:

Due Date: 12/4/17

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/2/17	0.00	0.00	Start Up Waterjet		DL 17/12/03
100	Waterjet	4 pcs		12/2/17	0.00	0.18	Waterjet1		DL 17/12/03
110	QC	4 pcs		12/2/17	0.00	0.00	QC2 Waterjet-1		DL DAS 17/12/03
120	QC	4 pcs		12/2/17	0.00	0.00	QC8-2		38
130	HandFinish	4 pcs		12/4/17	0.00	0.08	HandFinish1		2012-12-04 JSL
140	QC	4 pcs		12/4/17	0.00	0.00	QC3		38
150	Packaging	4 pcs		12/4/17	0.00	0.00	Packaging3	ST 627	SL 9-89
160	QC21-SA	4 Ea		12/4/17	0.00	0.00	QC21		

Part Op **100** - 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - QC3- Inspect Part Finish

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

DAS
21
9-89

DEC 06 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M5052H325.020	0	0	0	0

11 6041165020 - 5009813 - 1

Part Specifications

Specifications could not be found.

Plex 11/30/17 8:45 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____

DISPOSITION

AGAINST DEPARTMENT/PROCESS

Part No. _____

NCR No. _____

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

Skid-1 ☐
Machi ☐
Thermoform ☐
Large ☐

Date: _____ Step #: _____ QTY E _____

Description Work Order Deviation

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

ring ☐
ality ☐
ther ☐
Approval ☐

ed By _____

upervisor ☐
ification ☐

dinator ☐
al ☐

Root Cause

Environment ☐
Design ☐
Doc/Data ☐
Equip/Tooling ☐
Handling/Pre ☐
Material ☐
Internal Transport ☐
Tribal Knowledge ☐
LOA ☐
Substation ☐
Past Expiry Date ☐
Misidentified ☐

No Re-verification ☐
Operator ☐
Offset/Setup ☐
Supplier ☐
Training ☐
Use for Testing ☐
Poor Information ☐
Rushing ☐
Product Improvement ☐
Process Improvement ☐
Manufacturing Process ☐
Past Due ☐

Pressure/Forced ☐
Bending ☐
Centre Not Concentric ☐
Cracks ☐
Crimp/Kink/Ripple/Wave ☐
Cuffs ☐
Crushing ☐
Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐

Temperature/Cu ☐
Set-up ☐
BOM/Route ☐
Broken/Damage/ ☐
Inspection Incom ☐
Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incom ☐
Drill Holes ☐

DART
AEROSPACE
S016705



Plate

PART NO:
Revision:
Operation:
Change No:

D3238 - 13

Start up Operation

Mfg Date: 12/04/17
Job No: 169035

Misaligned/off center ☐

Turning Sequence ☐

DART AEROSPACE LTD		Work Order:	16100
Description: Plate		Part Number:	D3238-13
Inspection Dwg: D3238 Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>α</i>	Audited by:	<i>38</i> <i>9-89</i>	Prototype Approval:	N/A
Date:	<i>17/12/03</i>	Date:	<i>NOV 14 2017</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.02.23	Dwg Rev. updated	KJ/JLM <i>JA</i>	<i>FE</i>

DART

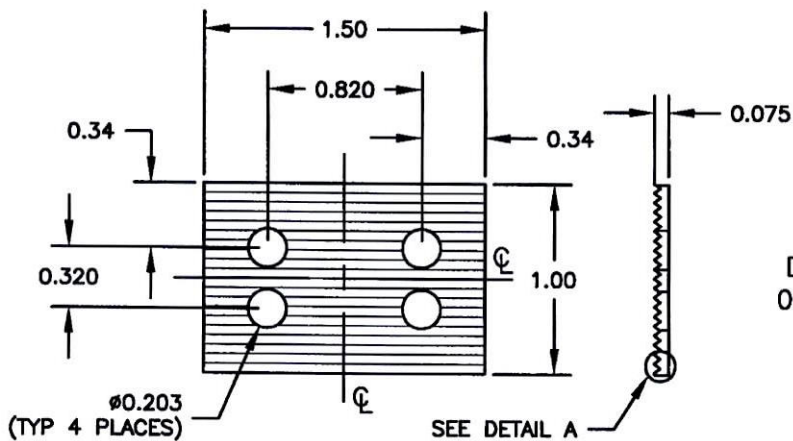
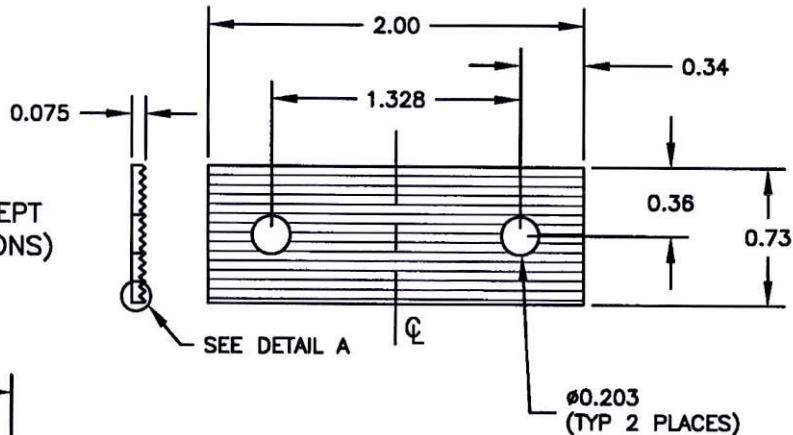
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)

D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

**D3238-3 PLATE (SHOWN)**

D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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